

Work Order ID 69292 *Split*

Friday, May 06, 2011 11:55:39 AM

Page 1

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 11-03-11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



Waterjet

FLOW WATERJET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537
Deburr if necessary

Dwg Rev: C

Prog Rev: C 2-

11-5-9

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11-5-9

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/09

11-5-9

Work Order ID 69292

Friday, May 06, 2011 11:55:40 AM



Page 2

Item ID: D3537-3

Accept



Revision ID:

Setup Start



Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00



Required Date: 5/9/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 11/05/09

15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

S 11/05/09

70

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

M117607

Pro →

X14 11-6-14
EL/PL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3537-3 PAR #: W/A Fault Category: Large Fab. welding NCR: Yes No DQA: A Date: 11.06.16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 11/06/17

NCR: <u>69292-2</u>		WORK ORDER NON-CONFORMANCE (NCR) <u># 65.15</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/14</u>	<u>150</u>	<u>Qty x2 Scrap due to welder training</u> <u>R.L. Training Engineer</u>	<u>W</u> <u>11/06/14</u>	<u>Scrap + Destroy</u> <u>no Repher</u>	<u>GBL</u> <u>11-6-14</u> <u>EL</u> <u>11-6-14</u>	<u>S</u> <u>11/06/14</u>	<u>W</u> <u>11/06/14</u>	<u>S</u> <u>11/06/14</u>

NOTE: Date & initial all entries

Work Order ID 69292

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Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QS1004- ground welds

0.00

QC

Memo

0.00

Quality Control

8 11/06/14

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8 11/06/14

(412)

180

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8-50
3200F
9-20

12x 11/06/16

M115128

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Page 4

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 5/6/2011 Start Qty: 12.00

Required Date: 5/9/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 x 11/06/16

200

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

12 x 11/06/16

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/06/16

11-06-16

Picklist Print

Friday, May 06, 2011 11:55:48 AM

Page 1

Work Order ID: 69292

Parent Item: D3537-3

Parent Item Name: Wearpad



Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	98,5000	0.149	1.882105	0.5		
304/316 Sheet .063													



1811-5-7

Location

Loc Qty

Loc Code

MAT020

98.5

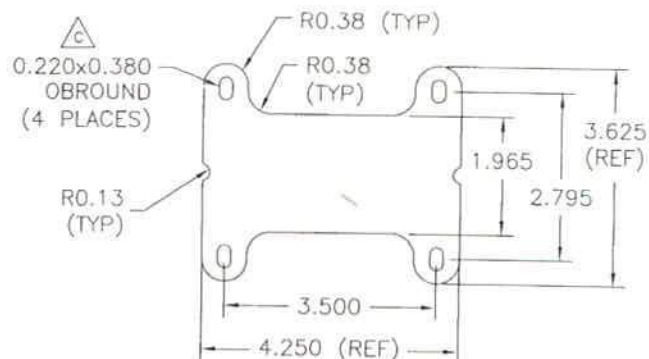
117275

98.5

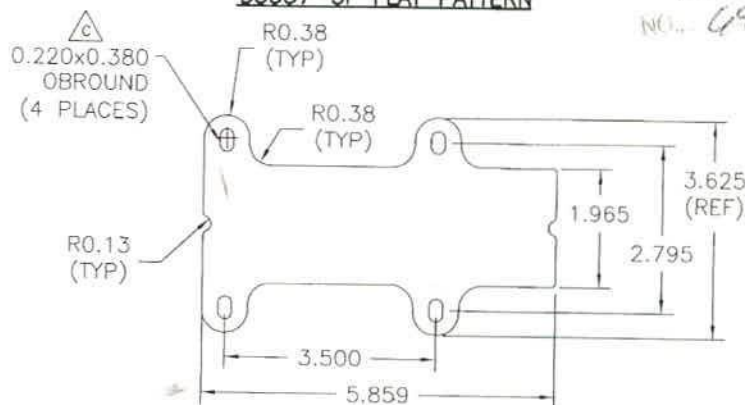
117275

15

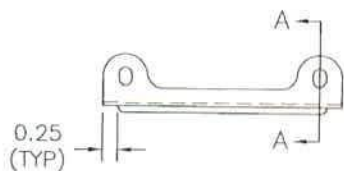
D3537-1F FLAT PATTERN



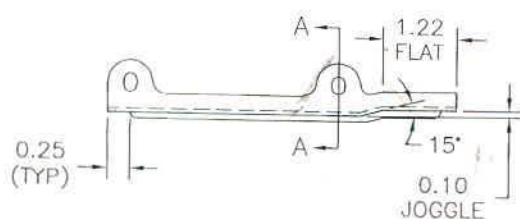
D3537-3F FLAT PATTERN



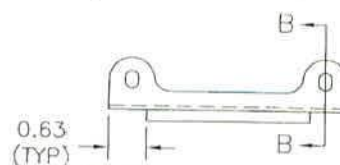
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

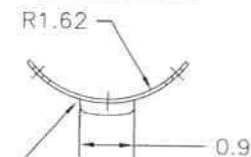
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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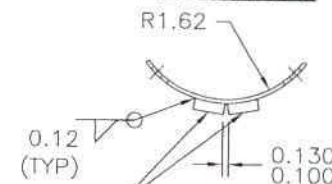
C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	A	APPROVED A
DATE	07.04.13	
DRAWING NO.	D3537	
TITLE	WEARPAD	
REV. C		
SHEET 1 OF 1		
SCALE		
1:2		

SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 PM
per ECH
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

